

Date:
User:Monday, 9/10/2007 1:31:52 PM
Kim Johnston

Process Sheet

SB split
07/10/05

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ASSEMBLY
 Job Number : 34517
 Estimate Number : 10464
 P.O. Number : *N/A*
 This Issue : 9/10/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL /MED FAB
 Previous Run : 34351
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est.A 04.04.19 New issue KJ/JLM
 EST B 07.08.21 Chg rivet per PAR185 EC Verified
 by: JLM

Part Number : D3278041
 Drawing Number : D3278 REV.C
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 10/2/2007 Qty: 40 Um: Eac

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 34517A SUPPORT



Comment: Sub-Component SUPPORT

D3278-1 B *34517A x 39mx, B 34351A x 1mx.* *MF*

2.0 34517B SUPPORT



Comment: Sub-Component SUPPORT

D3278-2 B *34657 x 9mx, B 34517D x 31mx,* *MF*

3.0 D32783 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Spacer

Pick:

Qty Part Number

Description

Batch

1 D3278-3

Spacer

Batch *34024* *16 mx* *B 34525 x 24mx* *MF*

4.0 MS20426AD36 Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

RIVET

Pick:

Qty Part Number

Description

Batch

4 MS20426AD3-6

Rivet

Batch *M105055* *MF* *07-10-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/05	1	Split w/o	SK	07/10/05	20		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 34517

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(20)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

mf 07-6-05

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/09/05 (20)

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2230-1

Mounting Lug

33250

mf

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4-13A

Bolt

m105426

mf

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD416

Washer

m104746

mf

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21042L4

Nut

m104683

mf

re: Monday, 9/10/2007 1:31:52 PM
/ser: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 34517

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble support as per Dwg D3278.
DO NOT TIGHTEN BOLTS
Identify as D3278-041

mf 07-10-05

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

caution
to 7/10/05 (20)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

7/10/05 50 (20X)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/10/05

Job Completion



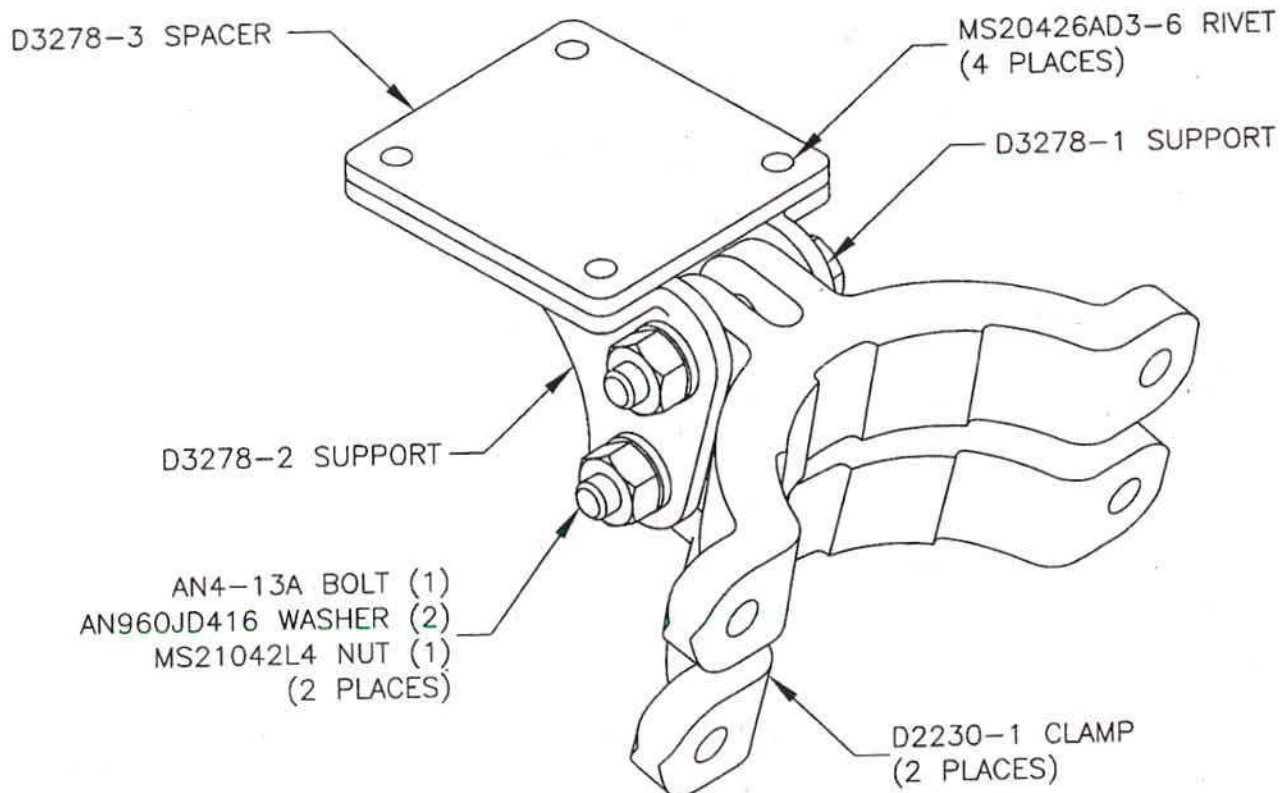
u 07-10-09

DART

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D3278	REV. SHEET 1 OF 1
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07 08 18

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDME
WITHOUT NOTICE
WORK ORDER
NO. 34517

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